

9/20/2018



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D117-762-041
Job Sheet 183544



Part No: D117-762-041

Job Qty: 1 ea

Part Name: Replacement Skidtube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/20/18

Job Tracking No:

Due Date: 10/19/18

Created By: Jesse White

Type: Stock

Description: SIOP

Note: DWG D3582 REV E IPP Rev:A 07.06.11 New Issue EC IPP Rev:B 08-02-22 change to revA as per dwg DD verF by:EC IPP REV:C 15.06.11 AS PER CHG002 DD VERF:JLM IPP REV:D 16.02.05 DWG REV:C (ecn16-514) DD VERF:JLM IPP REV:E 17.01.17 as per dwg REV.D DD VERF:JLM

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632 - 5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S113868



Part: D117-762-041

Job No: 183544

Serial No/Batch: S113868

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR01853SE 15/10/2016, T6 STC LoA RI

9/20/18 8:49 AM dart.w

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/19/18	0.00	0.00	Start Up Skid tubes-1		JS
130	Skid tubes	1 pcs		10/19/18	0.00	3.47	Skid tubes-1		BE
140	Skid tubes	1 pcs		10/19/18	0.00	3.47	Skid tubes-1		BE DAS
150	QC	1 pcs		10/19/18	0.00	0.00	QC10		38 DAS
160	QC	1 pcs		10/19/18	0.00	0.00	QC5		9-89 38
170	HandFinish	1 pcs		10/19/18	0.00	0.97	HandFinish1		DR 18/09/28
180	QC	1 pcs		10/19/18	0.00	0.00	QC7-1		BE
190	Skid tubes	1 pcs		10/19/18	0.00	3.47	Skid tubes-1		BE DAS
200	QC	1 pcs		10/19/18	0.00	0.00	QC10		38 DAS
210	QC	1 pcs		10/19/18	0.00	0.00	QC5		9-89 38
215	HandFinish	1 pcs		10/19/18	0.00	0.97	HandFinish2		DR 18/10/17
220	Powdercoat	1 pcs		10/19/18	0.00	0.26	Powdercoat1		BE 15-10-22
230	QC	1 pcs		10/19/18	0.00	0.00	QC3		DR 18-10-23
250	HandFinish	1 pcs		10/19/18	0.00	0.97	HandFinish4		BE 18-10-23
260	QC	1 pcs		10/19/18	0.00	0.00	QC5		OCT 25 2018 68
270	Packaging	1 pcs		10/19/18	0.00	0.00	Packaging3-1		OCT 25 2018 6 9-89
275	DC	1 pcs		10/19/18	0.00	0.00	DC		21 9-89
280	QC21-FG	1 Ea		10/19/18	0.00	0.00	QC21		DAS-89 OCT 25 2018

Part Op 130 - 1-Cut Aft end using DT8185 2-Deburr ends 3-Drill Aft Cap holes using DT8678 *** OPEN AFT CAP HOLES TO 0.1875" DIA
 Descriptions: *** 4-Locate DT 8973 from aft cap holes & Drill Ground wire hole on top of Tube. 5-Install 3/16 cleco in Ground wire hole, then drill all X-Bolt holes using 3/16" drill. 6-Drill pilot holes for wearplates using DT8900 7-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582. 8-Drill holes for D5520-1 doubler using DT10309 A & B, locating from 4th and 5th crossbolt holes from aft using .1875 clekos. Spot drill tube using #20 drill (note 10). Remove DT10309 B. Re-install DT 10309 A drill thru tube and doubler using #20 drill (note 10), cleko as you go. Remove .1875 clekos and open holes in tube and doubler to 0.750". Remove doublers and identify orientation. 9-Deburr doubler and doubler holes in skid tube. 10-Countersink doubler holes in skid tube as per Dwg. detail J and note 12 -Touch up alodine on D5520-1 doublers. 11-open ground wear holes to 0.391" as per section B-B 12-Open Aft Cap holes using .209" drill. 13-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size. 12-Do not open holes of section G-G to finishes size.

140 - 1-Weld fwd cap D2964 per dwg D3582 and QSI 004 A/R AL ROD Batch: 136158 2-Grind flush

190 - ***MASK OFF HOLES OF SECTION F-F (DO NOT C'SINK) 1-Open X-Bolt holes to finish size as per Dwg D3582, sections D-D, E-E, G-G as per Dwg. 2-Counter Sink X-BOLT holes as per Dwg D3582 D-D, E-E and G-G.***Do NOT countersink holes of section F-F). 3-Deburr and blow out chips from inside of tube, prep. tube for welding. 4-Install doublers using DT10309 B. Shave rivets as required. 5-Bond web as per Dwg D3582 & QSI 015 A/R 241 Sika Flex Batch: M138943 Exp Date: MAR 06 2019 6- Swage x-bolt spacer as per dwg and Section F-F QSI002. 7-Weld x-bolt spacers as per Dwg D3582 section D-D, E-E and G-G. A/R AL ROD Batch: 136158 8-Grind welds flush

215 - Touch-up alodine as per QSI

220 - START TIME 9:25 OVEN TEMPERATURE: 320° FINISH TIME: 9:55

250 - 1-Inspect for Foreign objects 2-Install Aft cap as per Dwg D3582, Detail "C" A/R 241 Sika Flex Batch: M138943 Exp Date: 19-3 3-Install Wearplates as per Dwg D3582, Note: Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582 *****Do not install bolts where indicated on Dwg(Note #6)***** 4- Wing Walk as per Dwg D3582 and QSI 005 4.4

270 - Identify and pack for shipping as per PPP D117-762-041 Location :FG081

275 - Photocopy bluefile & type labels per PPP D117-762-041 CHG003

006046

Job BOM

Part / Item	Component Name	Quantity	Operation
D3582-1-BENT	Skidtube Assembly BK117	1 Ea (1 ea)	90-Start up Operation
D5520-1	Doubler	2 Ea (2 ea)	130-Skidtubes
D2964	Cap	1 Ea (1 ea)	140-Skidtubes
CR3212-5-05	Rivet	68 pcs (68 ea)	190-Skidtubes
D2971	Cross Bolt Spacer	1 Ea (1 ea)	190-Skidtubes
D3584-1	Web	1 Ea (1 ea)	190-Skidtubes
D3662-1	Crossbolt Spacer	3 Ea (3 ea)	190-Skidtubes
D3662-3	Crossbolt Spacer	1 Ea (1 ea)	190-Skidtubes
D5304-1	Crossbolt Spacer	4 Ea (2 ea)	190-Skidtubes
ALS4-1032-130	Rivnut	36 Ea (36 ea)	250-HandFinish
ALS4-428-165	Insert	2 Ea (2 ea)	250-HandFinish
AN3-5A	Bolt	2 Ea (2 ea)	250-HandFinish
AN3C4A	Bolt	28 Ea (28 ea)	250-HandFinish
AN4-4A	Bolt	2 Ea (2 ea)	250-HandFinish
D2965	Cap	1 Ea (1 ea)	250-HandFinish
D3508-11	Wearplate Aft Center	1 Ea (1 ea)	250-HandFinish
D3508-13	Wearplate Aft	1 Ea (1 ea)	250-HandFinish
D3508-3	Wearplate Fwd Center	1 Ea (1 ea)	250-HandFinish
D3508-9	Wearplate Fwd	1 Ea (1 ea)	250-HandFinish
D3558-11	Gasket Aft Center	1 Ea (1 ea)	250-HandFinish
D3558-13	Gasket Aft	1 Ea (1 ea)	250-HandFinish
D3558-3	Gasket Center Fwd	1 Ea (1 ea)	250-HandFinish
D3558-9	Gasket Fwd	1 Ea (1 ea)	250-HandFinish
NAS1149C0332R	Washer	28 Ea (28 ea)	250-HandFinish
NAS1149D0332J	Washer	2 Ea (2 ea)	250-HandFinish
NAS1149D0416J	Washer	2 Ea (2 ea)	250-HandFinish

Container
 5113768
 5082767
 5077380
 5089456
 5097624
 5106740
 5108712
 F81600
 5093587
 5007274
 505814
 5095480
 5095223
 5104458
 5045482
 5057121
 5089509
 5045056
 5089814
 5058253
 5088628
 5077343
 5088626
 5089465
 5100407
 F81631511

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3582-1-BENT	1	0	0
130-Skidtubes	D5520-1	2	20	0
140-Skidtubes	D2964	1	5	0
190-Skidtubes	CR3212-5-05	68	405	0
	D2971	1	34	0
	D3584-1	1	8	0
	D3662-1	3	18	0
	D3662-3	1	27	0
	D5304-1	2	27	0
250-HandFinish	ALS4-1032-130	36	12,174	0
	ALS4-428-165	2	52	0
	AN3-5A	2	307	0
	AN3C4A	28	2,349	0
	AN4-4A	2	71	0
	D2965	1	50	0
	D3508-11	1	5	0
	D3508-13	1	7	0
	D3508-3	1	4	0
	D3508-9	1	5	0
	D3558-11	1	5	0
	D3558-13	1	7	0
	D3558-3	1	8	0
	D3558-9	1	8	0
	NAS1149C0332R	28	5,311	0
	NAS1149D0332J	2	1,958	0
	NAS1149D0416J	2	2,862	0

Part Specifications

Specifications could not be found.